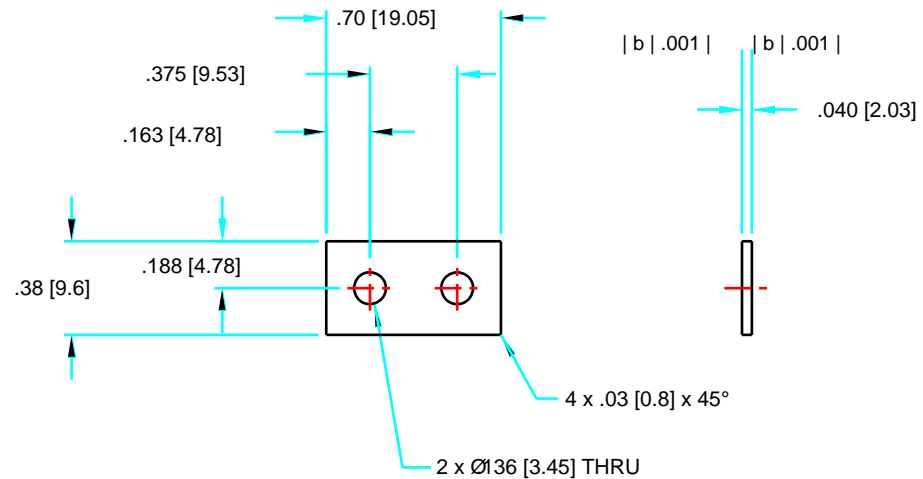


(B)

PLOT SCALE: 1=1

DWG. SCALE: 1

A2323001



NOTES:

1. THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
2. WHEN MACHINING VACUUM PARTS, USE SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL
3. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED. ¹
PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOWDOWN.
4. KEEP THE PART CLEAN AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
5. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY
6. SURFACE ROUGHNESS ⁶³

8

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES				
TOLERANCES				
DECIMALS				
X - .03				
XX - .01				
XXX - .005				
ANGULAR				
- .25				
SURFACE ROUGHNESS				
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.				
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1				
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5				
DO NOT SCALE DRAWING				
LOG NUMBER A2323001				
THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY				
DRAWN BY J.GOGOL				
DATE 8/25/95				
CHIEF DESIGN ENGINEER D.SHU				
DATE 8/31/95				
CHECKED BY J.CHANG				
DATE 8/31/95				
GP LEADER T.M.KUZAY				
DATE 8/31/95				
DESIGNER J.GOGOL				
DATE 8/25/95				
PROJECT MGR.				
RESPONSIBLE ENGINEER J.CHANG				
DATE 8/31/95				
APPROVED/RELEASED				
MATERIAL CARPENTER STEEL (39% NICKEL)				
SCALE 2:1				
SIZE B				
DRAWING NUMBER P4105091103-830008-01				
SHEET 1 of 1				

1	NOTE UPDATED;	J.G.	J.C.	11/16/95
SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				